

Date: Thursday, 07/08/2008 3:32:33 PM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HANDLE AND LOCK- DOWN ASSY  
 Job Number : 41065  
 Estimate Number : 13526  
 P.O. Number :  
 This Issue : 07/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : // Type : LARGE FAB ASSY  
 Previous Run :  
 Written By :  
 Checked & Approved By : MF 08-08-07  
 Comment : Est Rev:A 08-06-27 new issue DD verified by:ec

Part Number : D3451045  
 Drawing Number : D3451 REVA  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 14/08/2008 Qty: 5 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34515 Tube Handle Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Tube Handle Arm

batch: B 39957 ✓

SP 08-08-11

(5x) (5x)

2.0 GP211 Rubber Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rubber Handle

batch: M 103392

SP 08/08/14

(5)

3.0 PB6743001103 Tube Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube Handle

batch: B 41066

SP 08-08-11

(5x)

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld as per dwg PB67-43001

SP 08-08-11

(5x)

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

14/08/08/11 (5)

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Part Number: D3451045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 8/8/11 (X5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten signature*

08-08-11

8.0

POWDER COATING

POWDER COATING



M102316



(5X)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

7:40

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:10

*Handwritten signature* 08/08/12

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-12

(X5)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble rubber handle as per dwg PB67-43001

SB 08/08/14

(5)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 (X5)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PAT E.

S 08/08/126

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2008

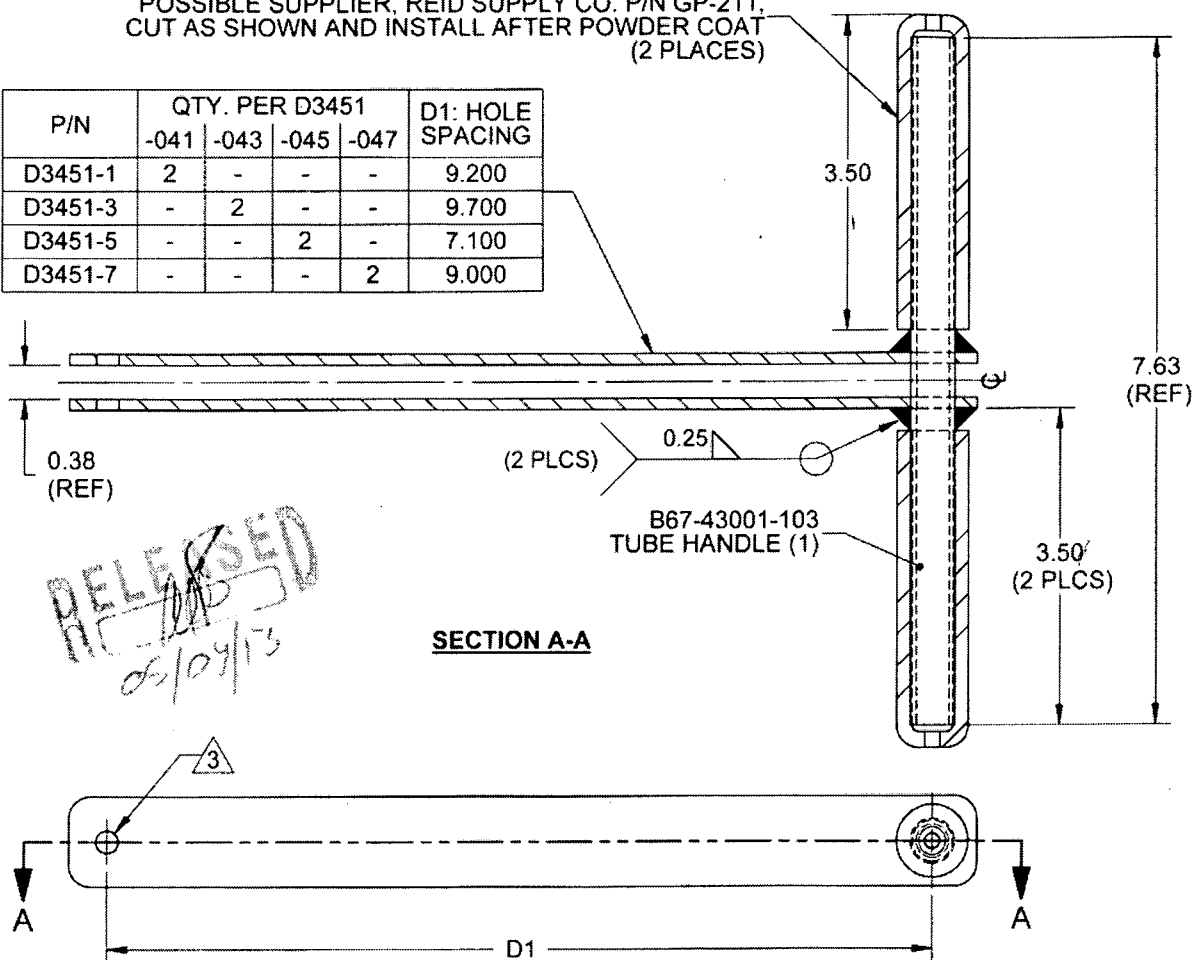
W 08/08/26



DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3451</b>	REV. A SHEET 1 OF 2
DATE <b>05.08.25</b>	TITLE <b>HANDLE &amp; LOCK-DOWN ASS'Y</b> SCALE 1:2		
A	05.08.25	NEW ISSUE	

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,  
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211,  
CUT AS SHOWN AND INSTALL AFTER POWDER COAT  
(2 PLACES)

P/N	QTY. PER D3451				D1: HOLE SPACING
	-041	-043	-045	-047	
D3451-1	2	-	-	-	9.200
D3451-3	-	2	-	-	9.700
D3451-5	-	-	2	-	7.100
D3451-7	-	-	-	2	9.000



**SECTION A-A**

**D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y**

**D3451-041 SUPERSEDES PREMIER P/N B67-43001-41**

**D3451-045 SUPERSEDES PREMIER P/N B67-43001-39**

**D3451-047 SUPERSEDES PREMIER P/N B67-43001-55**

**NOTES:**

- 1) WELD PER DART QSI 004.
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

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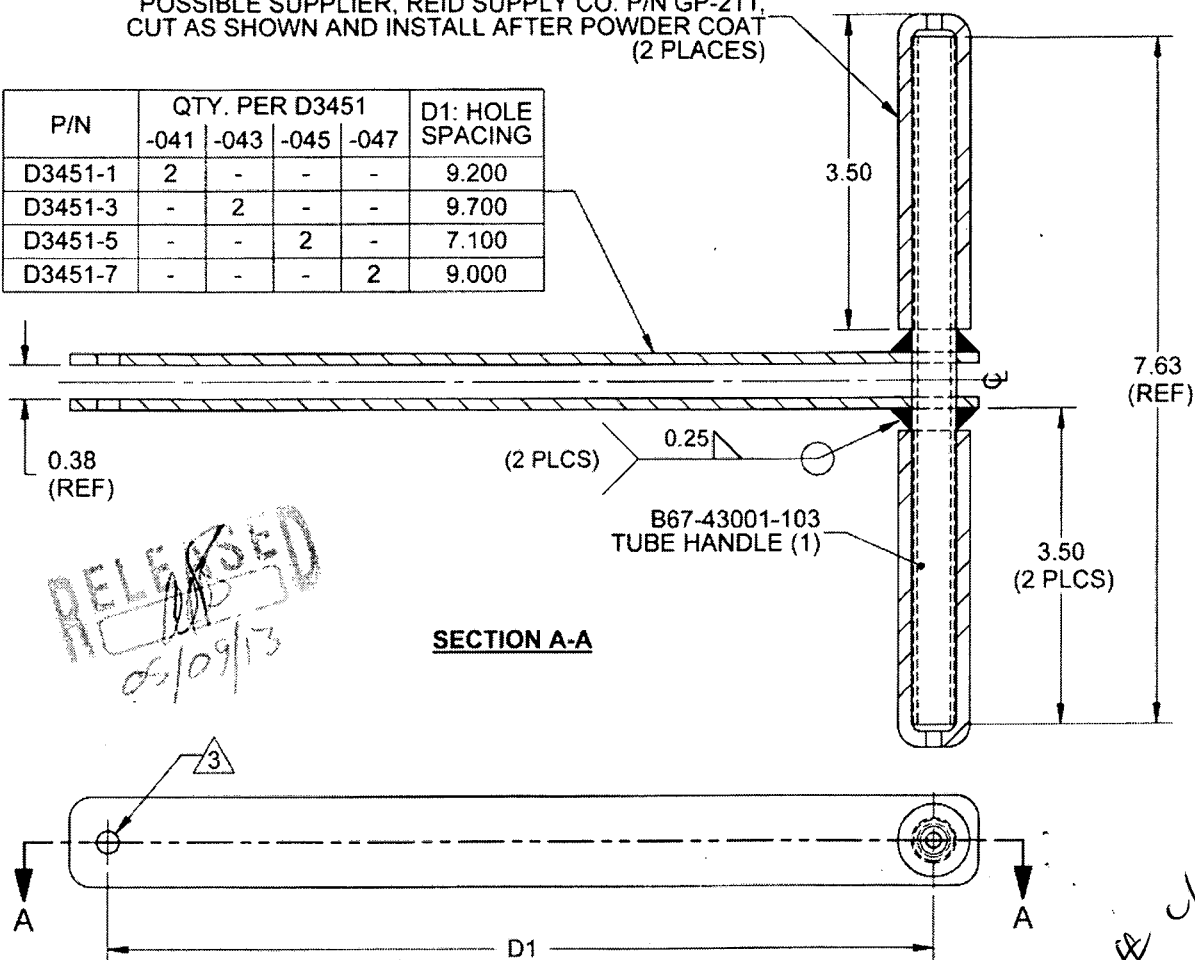
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